

Date: Tuesday, 13/05/2008 9:27:45 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HYDRAULIC CYLINDER			
Job Number	: 39219						
Estimate Number	: 12750						
P.O. Number	:			Part Number	: 41232 200 007 001		
This Issue	: 13/05/2008	S.O. No. :			Drawing Number	: 41232-200-007 REV IR	
Prsh Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type :	PURCHASED PARTS		Drawing Revision	: IR	
Previous Run	: 30942			Material	:		
Written By	:			Due Date	: 05/06/2008		
Checked & Approved By	<u>JUL 08-5-13</u>			Qty:	6 Um: Each		
Comment	: Est Rev:A New Issue 07-02-23 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	7D 1 H	Clippard Brass Cylinder	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Spring (Step Actuator)	
2.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>6357</u>	<u>C408/08/16</u>
		Possible Supplier: Wainbee	(6)
		Material release note is required	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	<u>AS 08/08/13</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>AS 08/08/13</u>
5.0	SPRAY PAINTING	SPRAY PAINTING	
		Comment: SPRAY PAINTING Mask threaded ends and threaded holes. 1-Apply polyimide primer Batch: <u>M109278</u>	<u>AS 08/09/16</u>
		2-Apply polyurethane coating gloss black Batch: <u>M109278</u>	<u>AS 08/09/16</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HYDRAULIC CYLINDER

Job Number: 39219

Part Number: 41232 200 007 001

Job Number:



Seq. #: Machine Or Operation:

Description :

Note: Paint Nut on threaded end and leave attached to assembly

6.0 QC14 INSPECT SPRAY PAINT



Sodar/18 (TG)

Comment: Inspect Spray Paint

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

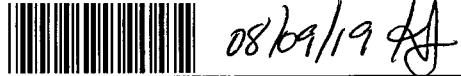
Install Decal then N/A - after assy due 08/09/19 +4 SYL v/r

Identify and Stock

Location: \_\_\_\_\_

C-85/18 (2)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/19 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



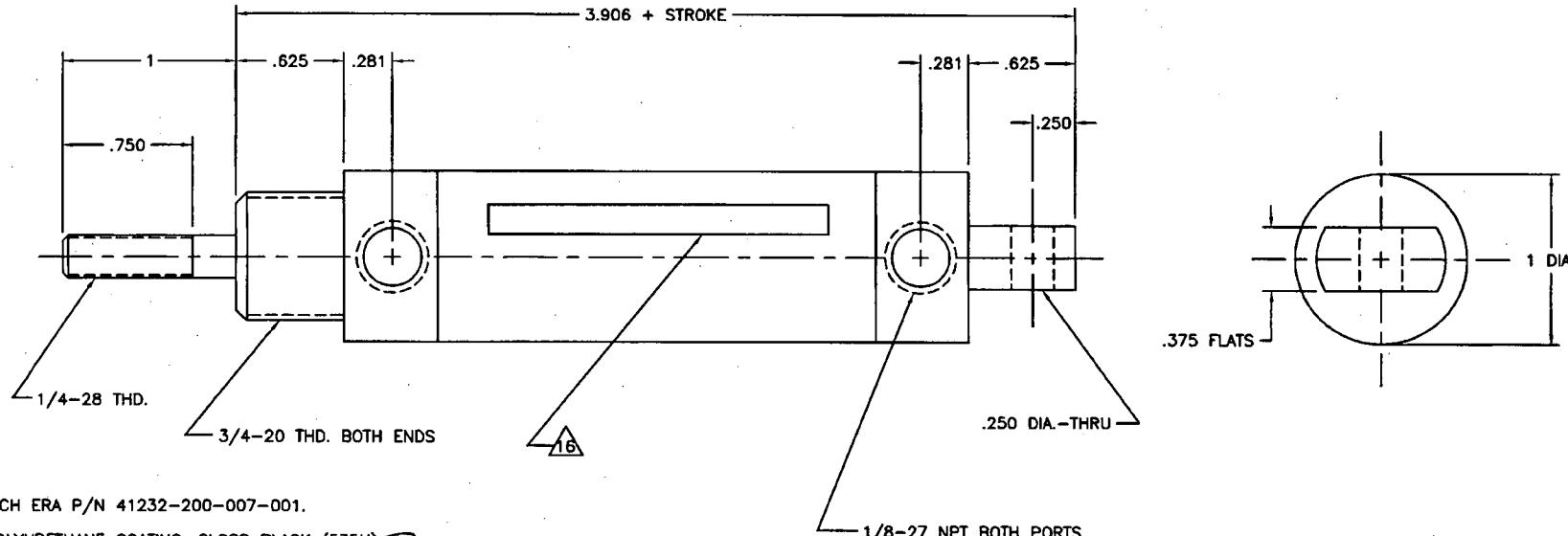
MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- VIBRO ETCH ERA P/N 41232-200-007-001.**

15. APPLY POLYURETHANE COATING, GLOSS BLACK (535U) IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4009.

14. APPLY POLYIMIDE PRIMER IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4004.

13. PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

NOTE - ALTER 7D1H ASSY IN ACCORDANCE WITH INSTRUCTIONS LISTED ABOVE.

12. SINTERED BRONZE ROD BUSHING.

11. ROD DIAMETER: 0.25 INCHES.

10. PORTS: 1/8 NPT.

9. POWER FACTOR: 0.6 SQ. IN.

8. STROKE: 1.000 INCH.

7. ACTION: DOUBLE ACTING.

6. MOUNT: UNIVERSAL MOUNT.

5. TEMPERATURE RANGE: 30° F TO 230° F.

4. 7D1H CONFIGURED WITH HYD. FLUID SEALS.

3. ROD: ROTATING.

2. BORE: 0.875 INCHES.

1. HEAVY DUTY BRASS CYLINDERS.

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39218

-001 BRASS CYLINDER

41232 200008001  
002

**NOTES:**

ONE ON ONE KILLED CO. 1  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39219

		-001	BRASS CYLINDER 7D1H	CLIPPARD INSTRUMENT LABORATORY, INC., CINCINNATI, OH.				
		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE	
NO. REQ'D PER ASSY		LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROVIDED BY ERICA AVIATION, INC. DISCLOSURE OR REPRODUCTION IN WHOLE OR IN PART OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN EXCEPT WITH WRITTEN AUTHORIZATION FROM ERICA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		UNLESS OTHERWISE SPECIFIED X.2.1	DRAFTSMAN D. NELSON CHECK D. MURPHY STRESS PROJ. ENGR.	3/14/03 3/14/03	TITLE HYDRAULIC CYLINDER (ALTERED ITEM DRAWING)			
-001	2	41232-000-001	ANGLES $\pm 1/2$	HEAT TREAT	C	SCALE NONE	DRAW. NO. 41232-200-007	REV. IR
REQ'D PER ASSEMBLY	NEXT ASSEMBLY	REV.						



WAINBEE LIMITED  
215 BOUL BRUNSWICK  
POINTE CLAIRE, PQ H9R 4R7  
Phone: 514-697-8810 Fax: 514-697-3070

## Packing List

CUSTOMER P/O NUMBER
:6357
RELEASE #
11199957-1
DATE
08/12/08 09:44:43

127404  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
613-632-3336

SHIP TO  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7

ORDER NUMBER	ORDER DATE	SHIP DATE	WRITTEN BY	CONTACT
11199957	07/16/08	08/12/08	Martin Lessard	CLAVOIE

CUSTOMER P/O NUMBER	
:6357	

JOB #	
P	

RELEASE #

PRODUCT / DESCRIPTION	QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE / EXTENSION
7D-1-H CLIPPARD BRASS CYLINDER	6	EA	6	0	76.210

8/16/08/13

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.